

# Work Order ID 65095

Thursday, January 06, 2011 10:41:43 AM



Page 1

Item ID: D3912-1

Accept



Setup Start



Revision ID:

Item Name: Eyebolt

Stop



Start Date: 1/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 11-01-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

0.00



Doosan

Memo

0.00

Doosan Lathe

TURN AS PER FOLIO FA871AND DWG

Prog Rev:

Dwg Rev:

*Handwritten: B, 11/1/26*

Deburr as required

*Handwritten: 6, 6*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*Handwritten: 11/1/26*

*Handwritten: 6, 6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65095**

Thursday, January 06, 2011 10:41:43 AM



Page 2

Item ID: D3912-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt

Start Date: 1/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

*11.1.24**6**0*

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: *09/*

0.00



Packaging

Memo

0.00

Packaging

*11/01/27 (6)*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/01/27**11-01-27 (6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, January 06, 2011 10:41:49 AM

Page 1

Work Order ID: 65095

Parent Item: D3912-1

Parent Item Name: Eyebolt



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303R2.000

Purchased

No

100

f

0.0000

0.25

1.578947



303 ROUND BAR 2"



~~1.578947~~ RA 11/1/2011

M116656

1.6 RA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	650 85
<b>Description: Eyebolt</b>		<b>Part Number:</b>	D3912-1
<b>Inspection Dwg: D3912 Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.131	/		U/L	SA-9
Ø0.700	+/-0.010	Ø.700	/			
Ø0.500	+/-0.010	Ø.502	/			
0.90	+/-0.030	.900	/			
0.13 x 45°	+/-0.030 x 0.5°	.150 x 45°	/			
0.22	+/-0.030	.219	/			
0.75	+/-0.030	.751	/			
0.970	+/-0.010	.965	/			
1.72	+/-0.030	1.713	/			
1.20	+/-0.030	1.201	/			
0.625	+/-0.010	.626	/			
2.23	+/-0.030	2.230	/			
R0.13	+/-0.030	R.120	/		RA	
R0.015	+/-0.010	R.015	/			
0.625	+/-0.010	.625	/			
Ø0.650	+/-0.010	Ø.650	/			
1.100	+/-0.010	1.094	/			
0.44	+/-0.030	.440	/			
R0.13	+/-0.030	R.120	/		RA	
1.00	+/-0.030	1.010	/			
0.25	+/-0.030	.245	/			
0.88	+/-0.030	.882	/			
0.11	+/-0.030	.108	/			
Ø0.719	+0.010/-0.000	Ø.724	/			

<b>Measured by:</b>	SA	<b>Audited by:</b>	SA	<b>Preliminary Approval:</b>	
<b>Date:</b>	11/1/26	<b>Date:</b>	11.1.26	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	SA

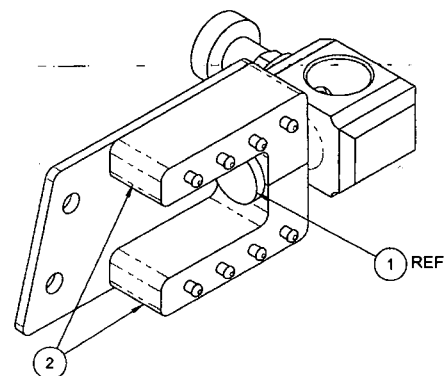
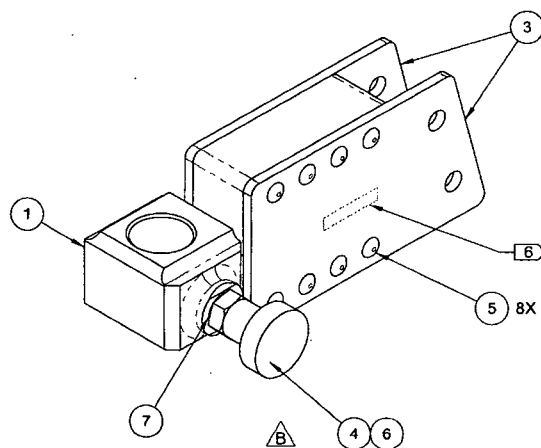




ITEM	QTY	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER

~~GROUP COPY~~  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 65095

BS11-01-4



SUPPLEMENTAL ISO VIEW  
 (EYEBOLT PLATE REMOVED  
 TO SHOW INTERIOR FEATURES)

# **D3912-041 EYEBOLT RECEIVER ASSY**

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: -041: 1.58 lbs

RELEASED  
 2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1.5		
DRAWN	1.1		
CHECKED	1.1		
MFG. APPR.	1.1		
APPROVED	1.1		
DE APPR.	1.1		
DATE	10.06.28		

DART AEROSPACE LTD  
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3912  
 TITLE EYEBOLT RECEIVER ASSY  
 REV. B  
 SHEET 1 OF 3  
 SCALE NTS

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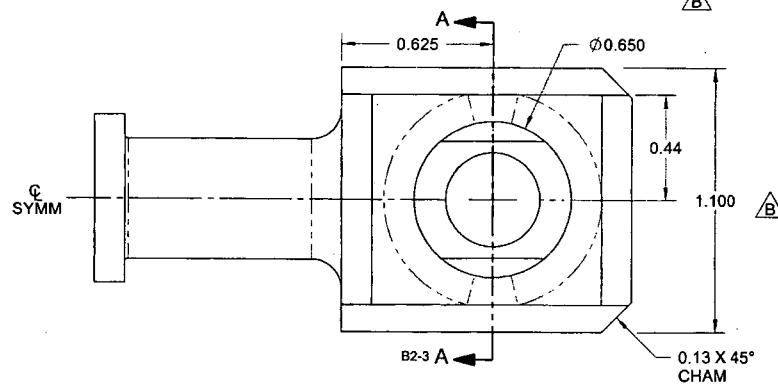
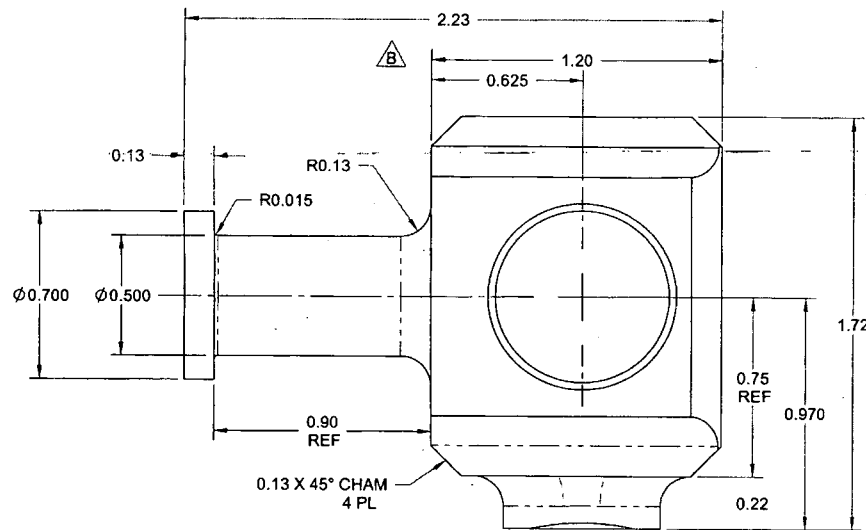
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

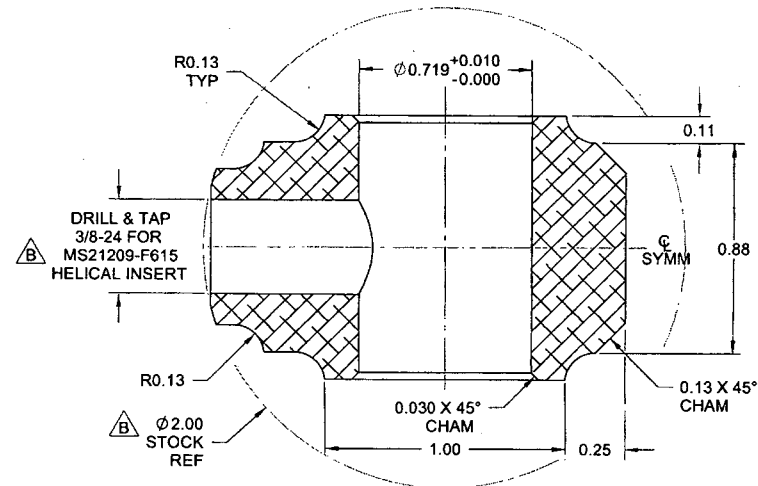
**NOTE:** Date & initial all entries



### D3912-1 EYEBOLT

#### NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



#### SECTION A-A B6-3

**RELEASED**  
2010-07-16  
JWP

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	JL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JL	DRAWING NO.	REV. B
MFG. APPR.	JL	D3912	SHEET 2 OF 3
APPROVED	JL	TITLE	SCALE
DE APPR.	JL	<b>EYEBOLT RECEIVER ASSY</b>	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

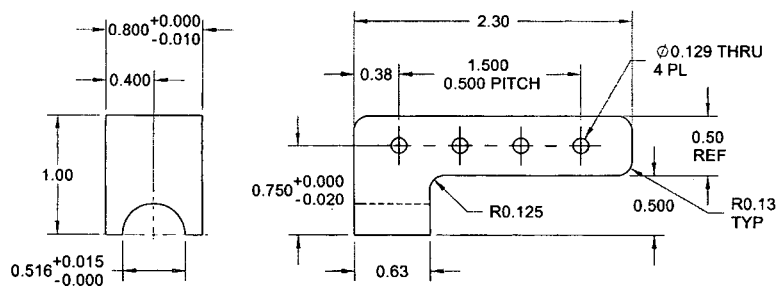
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

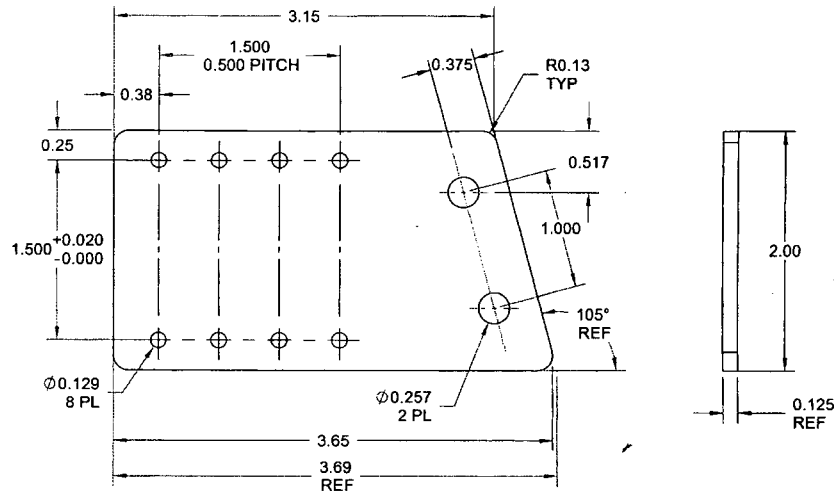
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

045095



**D3912-3 EYEBOLT BLOCK**



**D3912-5 EYEBOLT PLATE**

- NOTES:
- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ID AT ASSEMBLY
  - 7) WEIGHT -3: 0.30 lbs  
-5: 0.24 lbs

RELEASED  
2010-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AT	DRAWING NO.	REV. B
MFG. APPR.	AT	D3912	SHEET 3 OF 3
APPROVED	AT	TITLE	SCALE
DE APPR.	AT	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries